



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3278-2

Job Sheet 179494



Part No: D3278-2

Job Qty: 30 ea

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/19/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		7/6/18	0.00	0.00	Start Up Machining-2		N/R
100	Bandsaw	30 pcs		7/6/18	0.00	1.50	Bandsaw1		N/R
110	CNC Vertical Machining	30 pcs		7/6/18	0.06	12.88	HAAS 5 Axis		N/R
120	Outsource <i>Purch.</i>	30 pcs		7/6/18			MEM001-VC		<i>18.07.10.</i>
130	QC	30 pcs		7/6/18	0.00	0.00	QC8 Machining-2	<i>QC6</i>	<i>38</i>
140	HandFinish	30 pcs		7/6/18	0.00	3.09	HandFinish1		<i>9-89</i>
150	Powdercoat	30 pcs		7/6/18	0.00	0.62	Powdercoat1		<i>BR 18-7-13.</i>
160	QC	30 pcs		7/6/18	0.00	0.00	QC3		<i>38</i>
170	Packaging	30 pcs		7/6/18	0.00	0.00	Packaging3-1	<i>CM19</i>	<i>JUL 16 2018</i>
180	QC21-SA	30 Ea		7/6/18	0.00	0.00	QC21		<i>53</i>

Part Op 100 - Cut blank: 2.00" x 1.00" x 2.550" long
Descriptions: 150 - START TIME: *7.40* *OUT: 300° FINISH: 8:10.*
170 - LOCATION : GA

BR 18-7-13.
53
9-89
JUL 16 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	6.5100 ft (.217 ea)	90-Start up Operation	<i>5021854 x44</i> <i>5047296 x2</i> <i>M138152 x6</i>

9.4'
-5'
1.3'

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X02.000	7	23	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	0.098inches + 0.005 - 0.000	0.103 0.098		
2	Support	0.359inches ± 0.005	0.364 0.354		
3	Support	0.609inches ± 0.010	0.619 0.599		
4	Support	0.250inches ± 0.010	0.260 0.240		
5	Support	1.480inches ± 0.005	1.485		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		

Root Cause		Pre Ber Cer Cra Cria Cuf Cru He: Wa Ma OT
Environment ☐	No Re-verification ☐	
Design ☐	Operator ☐	
Doc/Data ☐	Offset/Setup ☐	
Equip/Tooling ☐	Supplier ☐	
Handling/Pre ☐	Training ☐	
Material ☐	Use for Testing ☐	
Internal Transport ☐	Poor Information ☐	
Tribal Knowledge ☐	Rushing ☐	
LOA ☐	Product Improvement ☐	
Substation ☐	Process Improvement ☐	
Past Expiry Date ☐	Manufacturing Process ☐	
Misidentified ☐	Past Due ☐	

Container No: S083043

Part: D3278 - 2

Job No: 179494

Serial No/Batch: S083043

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: _____

Date: 06/21/18

S090491

- ☐ Positioned Wrong
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Drawing
- ☐ Finish
- ☐ Misread
- ☐ Turning Sequence

			1.475
6	Support	0.125inches $\pm$ 0.010	0.135 0.115
7	Support	0.119inches + 0.005 - 0.004	0.124 0.115
8	Support	2.439inches $\pm$ 0.010	2.449 2.429
9	Support	1.980inches $\pm$ 0.010	1.990 1.970
10	Support	0.130inches $\pm$ 0.030	0.160 0.100
11	Support	0.257inches + 0.005 - 0.000	0.262 0.257
12	Support	0.375inches $\pm$ 0.010	0.385 0.365
13	Support	0.875inches $\pm$ 0.010	0.885 0.865
14	Support	0.500inches $\pm$ 0.010	0.510 0.490
15	Support	0.400inches $\pm$ 0.010	0.410 0.390
16	Support	1.000inches $\pm$ 0.030	1.030 0.970
17	Support	1.720inches $\pm$ 0.010	1.730 1.710
18	Support	0.125inches $\pm$ 0.010	0.135 0.115
19	Support	0.125inches $\pm$ 0.010	0.135 0.115

Plex 6/19/18 3:20 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040306**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040306

PO Date: 6/22/18

Due Date: 6/29/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		D3278-1			Support	Firmed	6/29/18	52 pcs	0 pcs x52	52 pcs	\$23.20/pcs 18.07.10	\$1,206.40
Line Item Note W/O 179492												
2		D3278-2			Support	Firmed	6/29/18	52 pcs	0 pcs x52	52 pcs	\$23.20/pcs 18.07.10	\$1,206.40
Line Item Note W/O 179494												
3		D5283-3P			Basket Clamp	Firmed	6/29/18	10 pcs	0 pcs 10x	10 pcs	\$52.75/pcs 18.06.28	\$527.50
Line Item Note W/O 179291												

Grand Total: \$2,940.30

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 6/28/18 10:29 AM dart.Lussier.Patrick



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 22809
Date: Jul 09, 2018
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO040306	Sold By: Walz, Christian D.
Shipped By: pick up	Ship Date: Jul 09, 2018

Description	Bin Loc	Unit	Quantity ordered	Quantity shipped	Quantity on B/O
D3278-1 Support, as per drawing D3278 Rev C unpainted		Each	52	52	
D3278-2 Support, as per drawing D3278-2 Rev C unpainted		Each	52	52	
D5283-3 Basket Clamp, no finishing unpainted		Each	10		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					
Received by _____			Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Material Batch #	Paint Batch #	P.O. Number
52	D3278-1	Support	S047296	Unpainted	40306
52	D3278-2	Support	M138152	Unpainted	40306

DAS
38
9-89

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, July 9, 2018